

Work Order ID 96803

96803

Page 1

Tuesday, February 05, 2013 9:12:49 AM

Item ID: D2940-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Support

Stop

NS2

Start Date: 2/5/2013

Start Qty: 20.00

20

Cust Item ID:

Required Books

Reference:

Approvals

Approvals: Process Plan: ✓ Date: 13-02-25 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____		DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Machining <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	
NCR No. _____		Work Order Update <input type="checkbox"/>			Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>	
		Initial Chief Eng	Action Description			Sign & Date	Verification	QC Inspector		
Root Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	Date	Step	Qty	Description of work order update or Non-conformance						
FAULT CATEGORY										
Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube	General									
	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>				Pressure/Forced <input type="checkbox"/>			
	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>				Temperature/Cure <input type="checkbox"/>			
	Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>				Weld <input type="checkbox"/>			
	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>				Wrong Stock Pulled <input type="checkbox"/>			
	Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>							
	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>							
	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>							
	Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>	Other <input type="checkbox"/>							
	Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>								
	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>								
	Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>								

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Page 2

Item ID: D2940-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Support

Stop

NS2

Start Date: 2/5/2013 Start Qty: 20.00

20

Cust Item ID:

Required Date: 3/4/2013 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

HandFXtube

Hand Finishing Crosstubes

Memo

0.00

20

0

0

13-2-28

Per note 8 on page 1 of dwg D2940, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg.
24h of cure time.

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

AS
27
B3.1

20

Memo

0.00

170

Identify as per dwg & Stock Location: LGS2

0.00

20

0

0

13-3-1

170

Packaging

Packaging

Memo

0.00

NCR: Yes / No

DQA: Date:

WORK ORDER NON-COMPLIANCE / UPDATE

QA Closed: Date:

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Part No. _____											
NCR No. _____											
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending		Bend		Grain		Ovalized		Pressure/Forced			
Centre Not Concentric to O/S		BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure			
Cracks		Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld			
Crushed/Crimped.		Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled			
Cuffs		Contamination		Maintenance		Part Moved					
Heat Treat		Countersink		Mislabeled		Positioned Wrong					
Inspection Strip in Tube		Cut Too Short		Misread		Power Loss/Surge					
Ripples in Bend		Drill Holes		Offset							
Torque Waves in Extrusion		Drawing		Out of Calibration							
Turning Sequence		Finish		Out of Sequence							
Wave/Twist in Tube		Folio		Outside Dimensions							

Work Order ID 96803

Tuesday, February 05, 2013 9:12:49 AM

96803

Page 3

Item ID: D2940-1

Accept

Revision ID:

Item Name: Support

Start Date: 2/5/2013 Start Qty: 20.00

20

Required Date: 3/4/2013 Req'd Qty: 20.00

20

Reference:

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID
180

Operation
Description
QC21- Final Inspection - Work Order Release

Set Up/
Run Hours
0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC

Quality Control

Memo

0.00

13/3/14
[Signature]

PLB 631-

Picklist Print

Tuesday, February 05, 2013 9:13:44 AM

Page 1

Work Order ID: 96803

96803

Parent Item: D2940-1

D2940-1

Parent Item Name: Support

Start Date: 2/5/2013

Required Date: 3/4/2013

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP C 02.11.26Reformat; Added P/OKJ

IPP Rev:D Added priming as per Rev B 07-04-30 JLM

IPP E 08.03.19 Re-format Ec verified by DD

IPP Rev:F 08-10-22 add qc14 DD verified by:EC

IPP Rev:G

11.08.04 as per dwg rev.C DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK081		Manufactured	No			110	Each	11.0000	0.5	10.52632	**	SL 13-2-16	

DSK081

D2940-1 TURNING DETAIL

Location	Loc Qty	Loc Code
MAT060	11	
88241	1	
92615	10	/0

DART AEROSPACE LTD	Work Order:	9/803
Description: Ø3.250 Support	Part Number:	D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		250	250	250	250	250
AB	0.490	0.510		-500	-500	-500	-500	-500
AC	0.140	0.160		160	160	160	160	160
AD	3.510	3.530		3.516	3.516	3.520	3.520	3.520
AE	1.633	1.673		1.653	1.648	1.652	1.651	1.657
AF	1.493	1.513		1.501	1.496	1.498	1.497	1.507
AG	0.040	0.060		-052	-054	-052	-051	-054
AH	0.188	0.193		-188	-188	-188	-188	-188
AI	0.140	0.160		-148	-148	-148	-148	-149
AJ	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AK	0.040	0.060		-050	-050	-050	-050	-050
AL	0.010	0.020		-010	-010	-010	-010	-010
AM	0.140	0.160		-155	-155	-155	-155	-155
AN	0.350	0.450		-370	-370	-370	-370	-370
AO	0.240	0.260		-250	-250	-250	-250	-250
AP	0.150	0.170		-152	-151	-154	-154	-151
AQ	0.053	0.073		-063	-063	-063	-063	-063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		-261	-261	-261	-261	-261
AT	0.053	0.073		-063	-063	-063	-063	-063
AU	4.118	4.138		4.126	4.126	4.127	4.127	4.127
AV								
AW								
Accept/Reject								

Measured by: JL

Date: 13-02-17

Audited by: JL

DAS
08
9-89

Date: 13/02/17

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	M

DART AEROSPACE LTD	Work Order:	91803
Description: Ø3.250 Support	Part Number:	D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	24	38	49	510
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.160	.160	.160	.158	.158
AD	3.510	3.530		3.520	3.518	3.520	3.520	3.520
AE	1.633	1.673		1.653	1.653	1.660	1.660	1.660
AF	1.493	1.513		1.503	1.500	1.500	1.500	1.500
AG	0.040	0.060		.050	.050	.050	.045	.045
AH	0.188	0.193		.188	.188	.188	.188	.188
AI	0.140	0.160		.140	.143	.143	.146	.145
AJ	2.518	2.538		2.530	2.530	2.528	2.528	2.528
AK	0.040	0.060		.050	.050	.050	.050	.050
AL	0.010	0.020		.010	.010	.010	.010	.010
AM	0.140	0.160		.155	.155	.155	.155	.155
AN	0.350	0.450		.370	.370	.370	.370	.370
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.153	.152	.153	.155	.155
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.064	103.064	103.064
AS	0.260	0.267		.261	.261	.261	.261	.261
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.127	4.130	4.130	4.130	4.130
AV								
AW								
Accept/Reject								

Measured by: SL 100% 100%

Date: 13/02/18

DAS

08

9-89

Audited by: K-A

Date: 13/02/24

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	

DART AEROSPACE LTD	Work Order:	96803
Description: Ø3.250 Support	Part Number:	D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.158	.158	.158	.158	.158
AD	3.510	3.530		3.522	3.522	3.522	3.522	3.522
AE	1.633	1.673		1.660	1.660	1.660	1.660	1.660
AF	1.493	1.513		1.502	1.526	1.502	1.502	1.503
AG	0.040	0.060		.047	.048	.047	.047	.045
AH	0.188	0.193		.198	.188	.188	.188	.188
AI	0.140	0.160		.145	.144	.145	.145	.148
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		.047	.048	.047	.047	.045
AL	0.010	0.020		.010	.010	.010	.010	.010
AM	0.140	0.160		.150	.150	.150	.150	.150
AN	0.350	0.450		.370	.370	.370	.370	.370
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.160	.160	.160	.160	.160
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	105.64	103.64	103.64	103.64
AS	0.260	0.267		.260	.260	.260	.260	
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.128	4.128	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by: *BG*

Date: 13-02-18

Audited by: *B-A*

*DAG
08
9.09*

Date: 13/02/24

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
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DART AEROSPACE LTD	Work Order:	96803
Description: Ø3.250 Support	Part Number:	D2940-1
Inspection Dwg: D2940 Rev: C		Page 1 of 1

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AB	0.490	0.510		.500	.500	.500	.500	
AC	0.140	0.160		.158	.158	.158	.158	
AD	3.510	3.530		3.522	3.522	3.522	3.522	
AE	1.633	1.673		1.660	1.660	1.660	1.660	
AF	1.493	1.513		1.503	1.502	1.502	1.503	
AG	0.040	0.060		.045	.047	.045	.043	
AH	0.188	0.193		.188	.188	.188	.188	
AI	0.140	0.160		.149	.147	.147	.149	
AJ	2.518	2.538		2.528	2.528	2.528	2.528	
AK	0.040	0.060		.050	.050	.050	.050	
AL	0.010	0.020		.01	.010	.010	.010	
AM	0.140	0.160		.150	.150	.150	.150	
AN	0.350	0.450		.370	.370	.370	.370	
AO	0.240	0.260		.250	.250	.250	.250	
AP	0.150	0.170		.160	.160	.160	.160	
AQ	0.053	0.073		.063	.063	.063	.063	
AR	103.64	105.64		103.64	103.64	103.64	103.64	
AS	0.260	0.267		.260	.260	.260	.260	
AT	0.053	0.073		.063	.063	.063	.063	
AU	4.118	4.138		4.128	4.128	4.128	4.128	
AV								
AW								
Accept/Reject								

Measured by: BG

Date: 13-02-19

Audited by: J.A

DAS
08
9-99

Date: 13/02/24

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
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